

4693



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBA9935

Job Sheet 177149



JL-Sun

Part No: RBA9935

Job Qty: 6 ea

Part Name: Draw Bolt



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 5/8/18

Job Tracking No:

Due Date: 6/11/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBA9935 Rev. 2 IPP Rev. A 18.05.07 new issue DP Verify DD

Ship Via:

O/S

SHIP

676

7-13

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		6/11/18	0.00	0.00	Start Up Machining-4		
120	Lathe Conv	6 pcs		6/11/18	0.25	0.75	Lathe Conv-2		
130	QC	6 pcs		6/11/18	0.00	0.00	QC2 Machining-5		
140	Mill Conv	6 pcs		6/11/18	0.25	0.75	Mill Conv 2		
150	QC	6 pcs		6/11/18	0.00	0.00	QC2 Machining-5		
160	QC	6 pcs		6/11/18	0.00	0.00	QC8 Machining-5		
165	Small Fab	6 pcs		6/11/18	0.00	0.00	Small Fab-2		
166	QC	6 pcs		6/11/18	0.00	0.00	QC5		
170	Outsource	6 pcs		6/11/18	0.00	0.00	Outsource12		
180	Packaging	6 pcs		6/11/18	0.00	0.00	Packaging2		
190	QC	6 pcs		6/11/18	0.00	0.00	QC6		
200	Packaging	6 pcs		6/11/18	0.00	0.00	Packaging3-2		
210	QC21-FG	6 Ea		6/11/18	0.00	0.00	QC21		

Part Op 120 - 1-Machine as per DWG. 3.5" Long. 2-Deburr ***Machine tapered end long to accommodate bending done at Small Fab step. Small Fab will cut to finished length.***

140 - 1-Machine as per DWG. 2-Deburr ***Machine tapered end long to accommodate bending done at Small Fab step. Small Fab will cut to finished length.***

165 - 1-Form as per DWG. 2-Cut off excess 3-Deburr

170 - -Issue P/O to GROUPE ALTECH; PO 000465 -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required

180 - Receive

200 - IDENTIFY AND STOCK

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M1018R0.187	M1018R0.187	1.7400 ft (.29 ea)	90-Start up Operation	5074039

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M1018R0.187	2	12	0

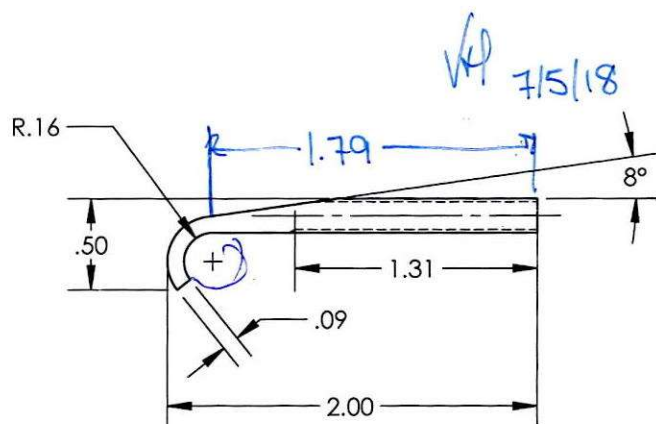
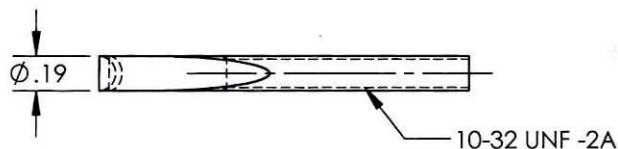
Part Specifications

Specifications could not be found.

Plex 6/21/18 10:26 AM dart.logan.david

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0285	CH'D MATERIAL CALLOUT WAS 1018 IS 1018/1020 CR. CH'D DIMS WAS R.156 IS R.16. WAS .090 IS .09. WAS .188 IS Ø.19. ADDED BLACK OXIDE SPEC. ADDED USED ON TOOLS RBA9928-9, RBA9929-5, RBA9929-9 AND RB600N9929-5, CH'D DWG. TO SHEET METAL TOLERANCE.	10/17/2016	RJC	JAG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 177149
20180621

NOTE:

- USED WITH RIGGING TOOLS INCLUDING:
RBA9928-5, RBA9928-9, RBA9928-19,
RBA9929-5, RBA9929-9 AND RB600N9929-5.

DART AEROSPACE	
TITLE DRAW BOLT	
DWG NO. RBA9935	REV 2
MAT'L 1018/1020 CR HEAT TREAT FINISH BLACK OXIDE SPEC QMSI-6.2.2, B.O. REV D DRAWN BY: COLE CHECKED: DUERFELDT OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125 ✓ 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL SEE NOTE 1	
SCALE 1:1	DATE 8/7/2000
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	DRAW BOLT	1018/1020 CR		

177149

RBA 9935

Versieren CLK-10
G0-10 G0
Angle Finder
Versieren CLK-10

18/7/6

Date:

Revised by
KJ

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>					Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																												
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Date : _____	Step #: _____				MRB (QSI042) Approval																																																												
Description Work Order Dart Aerospace Ltd. 12/11 Aberdeen Street Newbury, ON K6A 1K7 CANADA TEL: 1 813 632-6200 Email: sales@dartaero.com www.dartaerospace.com Date: 07/06/18 Container No: S089541 Part: RBA9935 Job No: 177149 Serial No/Batch: S089541 Revision: 2 Inspector: Exp Date: Instructions:					Completed By																																																												
					Lead hand / Supervisor Approval Verification																																																												
					QC / QA Coordinator Approval																																																												
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Certificat de Conformité / Certificate of Compliance

(011173-2)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

011173- 2

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.				
24-Jul-2018		Aman			040465				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order	
1	RBE-350DAMPER Rev.	RBE-350DAMPER 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	6	6	0	0	0	
4	RB6798927-4 Rev.	RB6798927-4 MIL-C-13924C CLASS 1 01 -OXIDE BLACK [OXIDE BLACK]	BLACK-OXIDE CH	6	6	0	0	0	
5	RBE350A94-2706-00-05 Rev.	RBE350A94-2706-00-05 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	3	3	0	0	0	
6	RBE350A94-2706-00-01 Rev.	RBE350A94-2706-00-01 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	24	24	0	0	0	
7	RBE350A94-2706-00-03 Rev.	RBE350A94-2706-00-03 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	BLACK-OXIDE CH	12	12	0	0	0	
8	RBE350A94-2706-00-07 Rev.	RBE350A94-2706-00-07 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	6	6	0	0	0	
9	RBE350A94-2706-00-09 Rev.	RBE350A94-2706-00-09 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	6	6	0	0	0	
10	RBA9935 Rev.	RBA9935 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	BLACK-OXIDE CH	6	6	0	0	0	
11	RBW6705G00632-3G-11 Rev.	RBW6705G00632-3G-11 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	6	6	0	0	0	

DAS
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9-89

(011173-2)

011173- 2

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Page 2 of 2



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO040465

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO040465
PO Date: 7/11/18
Due Date: 7/20/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	173844	RBE-350DAMPER	Damper Spanner Wrench -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	7/20/18	6 pcs	0 pcs	6 pcs	\$2.35/pcs	\$14.10
2	174441	RBW6305G00232-3G-5	Stop -Issue P/O to Groupe Altech: P/O _____ -Cadmium plating, QQ-P-416F TYPE II, CLASS II -Color; Yellow -Certificate of Conformity is required	Firmed	-	7/20/18	12 pcs	0 pcs	12 pcs	\$11.80/pcs	\$141.60
3	174442	RBW6305G00232-3G-7	Stud -Issue P/O to Groupe Altech: P/O _____ -Cadmium plating, QQ-P-416F TYPE II, CLASS II -Color; Yellow -Certificate of Conformity is required	Firmed	-	7/20/18	13 pcs	0 pcs	13 pcs	\$11.80/pcs	\$153.40

JUL 24 2018

JUL 24 2018

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	178391	RB6798927-4	Set Screw / Modified B/O -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; Steel -Certificate of Conformity is required	Firmed	-	7/20/18	6 pcs	0 pcs	6 pcs	\$1.60/pcs	\$9.60
5	172443	RBE350A94-2706-00-05	Pin -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	7/20/18	3 pcs	0 pcs	3 pcs	\$1.50/pcs	\$4.50
6	173903	RBE350A94-2706-00-01	Pin -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	7/20/18	24 pcs	0 pcs	24 pcs	\$1.50/pcs	\$36.00
7	173905	RBE350A94-2706-00-03	Pin -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	7/20/18	12 pcs	0 pcs	12 pcs	\$1.50/pcs	\$18.00
8	173909	RBE350A94-2706-00-07	Pin -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	7/20/18	6 pcs	0 pcs	6 pcs	\$1.50/pcs	\$9.00

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
9	173911	RBE350A94-2706-00-09	Pin -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	7/20/18	6 pcs	0 pcs	6 pcs	\$1.55/pcs	\$9.30
10	177149	RBA9935	Draw Bolt -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	-	7/20/18	6 pcs	0 pcs	6 pcs	\$1.75/pcs	\$10.50
11	178632	RBW6705G00632-3G-11	Washer -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Material; 1018 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	-	7/20/18	6 pcs	0 pcs	6 pcs	\$1.50/pcs	\$9.00
Grand Total:											\$415.00
Order Notes											
											

DAS
38
9-89

Order Notes**Procurement Quality Clauses**

A005 right of entry

A012 chemical and physical test report

A016 personnel qualification

A017 raw material identification (as applicable)

A022 Apical Processing

A024 process certifications

A026 certification of material conformance

A041 quality management system

A042 dart notification by supplier

A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 7/19/18 1:12 PM dart.tsimiklis.chrisoula